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October 26, 1956

FEDERAL SPECIFICATION

BEDPAN, CORROSION-RESISTING STEEL

This specification was approved by the Commissioner, Federal Supply Service, General Services Administration, for the use of all Federal agencies.

1. SCOPE

1.1 This specification covers a corrosion-resisting steel bedpan, suitable for use in hospitals and places where patients are confined to bed.

2. APPLICABLE SPECIFICATIONS AND STANDARDS

2.1 The following specification and standards, of the issues in effect on date of invitation for bids, form a part of this specification to the extent specified herein:

Federal Specifications:

PPP-B-585---Boxes; Wood, Wirebound.
PPP-B-601---Boxes, Wood, Cleated-Plywood.
PPP-B-621---Boxes, Wood, Nailed and Lock-Corner.
PPP-B-636---Box, Fiberboard.

Federal Standards:

Fed. Std. No. 66---Steel: Chemical Composition and Hardenability.
Fed. Std. No. 102---Preservation, Packaging, and Packing Levels
Fed. Std. No. 123---Marking for Domestic Shipment (Civilian Agencies).
Fed. Std. No. 151---Metals; Test Methods.

(Activities outside the Federal Government may obtain copies of Federal Specifications, Standards, and Handbooks as outlined under General Information in the Index of Federal Specifications, Standards, and Handbooks and at the prices indicated in the Index. The Index, which includes cumulative monthly supplements as issued, is for sale on a subscription basis by the Superintendent of Documents, U.S. Government Printing Offices, Washington 25, D.C.

(Single copies of this specification and other product specifications required by activities outside the Federal Government for bidding purposes are available without charge at the General Services Administration Regional Offices in Boston, New York, Washington, D.C., Atlanta, Chicago, Kansas City, Mo., Dallas, Denver, San Francisco, and Auburn, Wash.

(Federal Government activities may obtain copies of Federal Specifications, Standards and Handbooks and the Index of Federal Specifications, Standards, and Handbooks from established distribution points in their agencies.)

Military Specifications:

MIL-L-10547---Liners, Case, Waterproof.

Military Standards:

MIL-STD-105---Sampling Procedures and Tables for Inspection by Attributes.

MIL-STD-129---Marking for Shipment and Storage.

(Copies of Military Specifications and Standards required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the contracting officer.)

3. REQUIREMENTS

3.1 Material. The bedpan shall be made of AISI 304 corrosion-resisting steel conforming to Federal Standard No. 66, when tested as specified in 4.4.1.

3.2 Construction. The bedpan shall be formed from two pieces of corrosion-resisting steel not less than 0.031 inch thick (No. 22, United States Standards gage), which shall not be reduced below 0.027-inch thickness except for a maximum of 5 percent of the total area which shall not be reduced below 0.022-inch thickness at any point. The material shall be joined by welding. The bedpan shall have a tight, flat, single, rolled edge all around the opening at the top. The rolled edge shall be flow soldered to eliminate all traces of crevices. The bottom of the bedpan shall be embossed and concave.

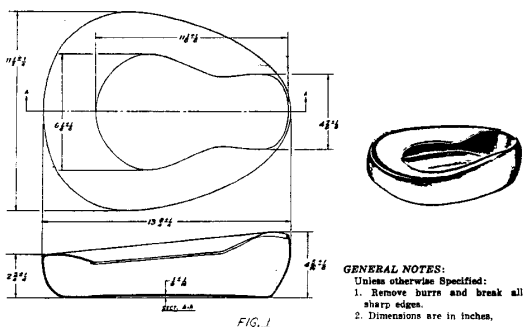
3.3. Design. Design shall be as shown on figure 1 or 2.

3.4 Dimensions and tolerances. Dimensions shall be as shown in figure 1 or 2.

3.5 Finish.

3.5.1 Grinding. The entire inside and outside surfaces shall be finished with a No. 200 emery after all surface imperfections have been removed by previous grinding. This last grinding shall produce a uniform finished surface substantially similar to a No. 4 commercial finish, with all imperfections and marks of previous grinds removed. The thickness of the sheet forming the bedpan shall not be reduced below the thickness specified in 3.2 by grinding to remove surface imperfections.

3.5.2 Cleaning. As a final operation, the bedpan shall be thoroughly cleaned to remove foreign particles, such as dirt, grease, graphite, and metal.



3.5.3 Resistance to corrosion. When tested as specified in 4.4.2, slight surface corrosion of the specimen which can easily be washed off shall not be

considered a cause for rejection, but if the specimen should rust or show continuous bleeding from pits it shall be considered as having failed to pass the test.

3.5.4 Alternate finish. The interior of the bedpan shall be finished by means of electropolishing. The final finish shall be a uniform, bright, shiny surface which can be readily cleaned.

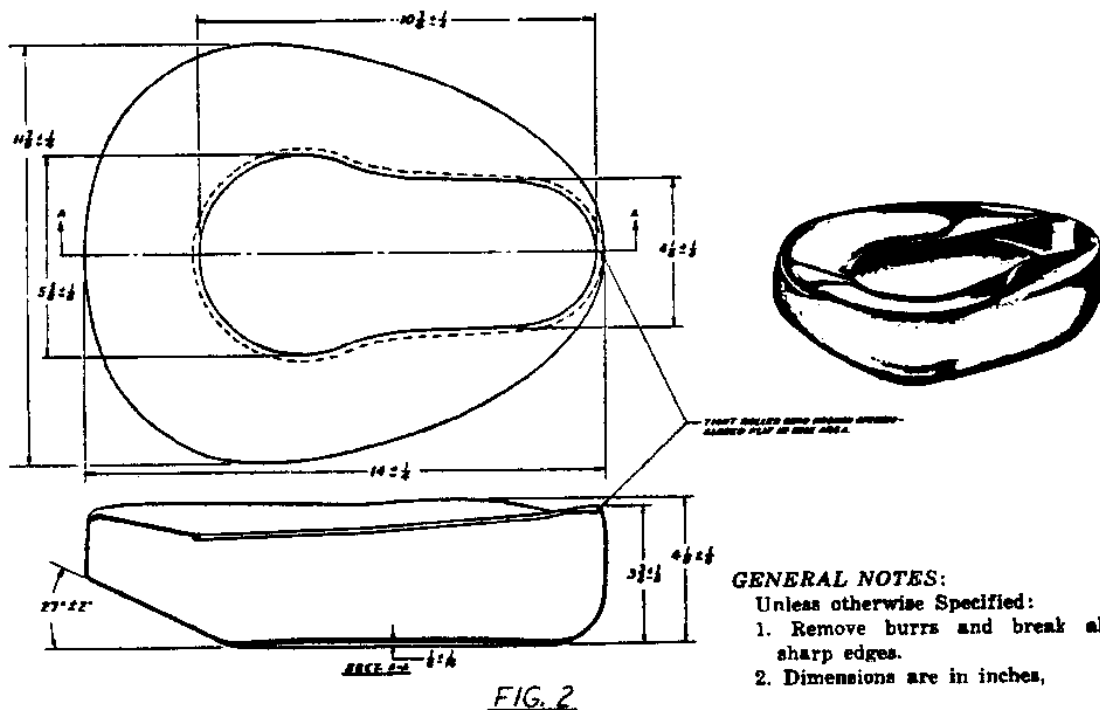
3.6 Identification marking. Each bedpan shall be impressed on the bottom with the manufacturer's name or registered trademark. When specifically required in the invitation for bids, the contract or purchase order number and the letters U.S. shall be impressed. All impressions shall be made at even pressure so as not to penetrate the inside surface of the bedpan.

3.7 Workmanship. Bedpans shall be free from defects which may affect their appearance or serviceability. Bedpans shall be free of rough grind marks, trimming marks, pits, scales, and other defects or imperfections. All surfaces shall have a smooth finish and shall be free of sharp edges.

3.7.1 Welding. All welding shall be done with suitable equipment and by skilled, thoroughly experienced welders. Welded joints shall be ground and polished to blend with the adjacent surfaces.

4. SAMPLING, INSPECTION, AND TEST PROCEDURES

4.1 Supplier responsibilities for inspection. The supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified, the supplier may utilize his own or any other inspection facilities and services acceptable to the Government. Inspection records of the examination and tests shall be kept complete and available to the Government as specified in the contract or order. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that supplies and services conform to prescribed requirements.



4.1.1 Inspection. Inspection, as used in this specification, is defined as both examination (such as visual, auditory, etc., investigation without the use of special laboratory appliances or procedures) and testing (determination by technical means of physical and chemical properties) of the item.

4.1.2 Certificates of quality. When available, certificates of quality, supplied by the manufacturer of the component or material, listing the specified test method and test results obtained, may be furnished in lieu of actual performance of such testing by the contractor.

4.2 Sampling.

4.2.1 For examination. Sampling for examination shall be conducted in accordance with MIL-STD-105.

	Inspection level	AQL (defects per hundred units)
For visual examination:		
Major defects	II	1.0
Total (major and minor combined) defects.....	II	4.0
For dimensional examination.	L5	2.5

4.2.2 For tests. Sampling for salt-spray test shall be conducted in accordance with inspection level L2 of MIL-STD-105. The acceptance number shall be zero and not less than three samples shall be taken regardless of lot size.

4.2.3 Raw materials. Four ounces of each lot of meal used in the construction of the bedpans shall be selected for chemical analysis.

4.3 Examination. The bedpans shall be examined to determine compliance with all requirements contained in this specification.

4.3.1 Classification of defects. Examination shall be conducted in accordance with the following classification of defects:

	Categories and defects*
Major:	
101	Rolled edge at opening not completely closed; crevices not filled with solder.
102	Welding joining two pieces not sound, or not free of spatter, cracks, and porosity.
103	Opening at top dies not have a tight, flat, single, rolled edge.
104	Rolled edge not free of crevices, sharpness, and burrs.
105	Bottom not concave and embossed.
106	Identification marking incomplete or illegible.
Minor:	
201	Welded joint not properly ground; does not blend with adjacent surfaces.
202	Unit not free of dirt, grease, graphite, metallic particles, and other foreign substances.
203	Surface not free of pits, scales, scratches, and grinding and trimming marks.
204	Inside surface of the bottom penetrated by marking impressions.
205	Bedpan does not rest on a flat surface without rock or wobble.

* Examination shall not be restricted to the classified possible defects listed above.

4.3.2 Dimensional examinations. The bedpan shall be examined for defects in dimensions. Any dimension not within the tolerances specified herein shall be classified as a defect.

4.4 Tests. Tests shall be conducted, as necessary, to determine compliance with specification requirements.

4.4.1 Chemical composition. Tests for chemical analysis shall be conducted in accordance with method 111.1 or 112.1 of Fed. Test Method Std. No. 151.

4.4.2 Salt spray. Bedpans shall be tested in accordance with method 811.1 of Fed. Test Method Std. No. 151, for a period of 48 hours.

5. PREPARATION FOR DELIVERY

The levels of preservation, packaging, and packing protection used are defined in Fed. Std.No. 102 (for civil agencies only).

5.1 Packaging.

5.1.1 Level A or B. Each bedpan shall be packaged in a carton of appropriate size constructed in accordance with PPP-B-636, type I, class 1. Closure shall be effected in such a manner as to prevent spillage of contents under normal handling.

5.1.2 Level C. Bedpans shall be wrapped in kraft paper and packaged in standard commercial containers of the size and kind commonly used, which will afford the degree of protection required for shipment and use of the product for its intended purpose within the continental limits of the United States of America.

5.2 Packing.

5.2.1 Level A. Twelve bedpans packaged as specified in 5.1.1 shall be packed in exterior containers designed for type 2 load and constructed in accordance with PPP-B-585, style 3, for class 3 use; PPP-B-601, table II, using type III, class 1 plywood; or PPP-B-621, table III. Each level A box shall be lined with a waterproof case liner conforming to MIL-L-10547. Closure and sealing shall conform to applicable paragraphs of appendix thereto. Strapping, when required, shall be in accordance with applicable box specification.

NOTE: Strapping will not be required for shipments forwarded to a receiving activity within the continental limits of the United States for storage and redistribution.

5.2.2. Level B. Twelve bedpans packaged as specified in 5.1.1 shall be packed in exterior containers constructed in accordance with PPP-B-6211, table I, or PPP-B-636, type I, class 1, fabricated from not less than 275-pound test fiberboard.

5.2.3 Level C. The subject commodity shall be packed in substantial commercial containers of the type, size, and kind commonly used for the purpose, so constructed as to insure acceptance and safe delivery by common or other

carriers, at the lowest rate, to point of delivery called for in the contract or order.

5.3 Marking.

5.3.1 Civil agencies. In addition to any special marking required by the contract or order, unit packages and shipping containers shall be marked in accordance with Fed. St. No. 123.

5.3.2 Military activities.

5.3.2.1 Interior packages. Each unit package and each intermediate package shall be marked in accordance with section 5 of MIL-STD-129.

5.3.2.2 Exterior container. Exterior container shall be marked in accordance with MIL-STD-129.

6. NOTES

6.1 Ordering data. Procurement documents should specify the following:

- (a) Number and date of this specification.
- (b) Selection of identification marking (3.6)
- (c) Selection of applicable levels of packaging and packing (see 5.1 and 5.2).

6.2 This specification does not include all types, classes, grades, sizes, etc, of the commodity indicated by the title of this specification, or which are commercially available, but it is intended to cover the types, etc., which are normally procured to meet Federal Government requirements.

6.3 Transportation. Transportation description applicable to this item is:

Sheet steelware, not otherwise indexed by name (bedpans). Specify nested, not nested or nested solid, flat or folded flat.)

Carload minimum weight 20,000 pounds, subject to Rule 34, Uniform Freight Classification.

Sheet steel articles, not otherwise indexed (bedpans). (Specify nested, not nested or nested solid, flat or folded flat.)

Truckload minimum weight 20,000 pounds.

Notice. When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications or other data, is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

MILITARY CUSTODIANS:

Army---M

Navy---Md

Air Force---AFCSG

Copies of this specification may be purchased for 5 cents each.